

March-06-14 7:56:19 AM

1 14465

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Step Assembly RH, 206 Float

Start Date: 3/06/14 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 3/14/14 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: _____ **Process Plan:** [Signature] **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2842	Rev B

0.00

100

Large Fab

0.00

Large Fab

Memo

Large Fab

- 1-Cut D2842-1 using D2622 extrusion as per Dwg D2842
- 2-Drill D2842-1 using Jig DT8272 as per Dwg D2842
- 3-Deburr and bevel ends for welding

105

QC6- Inspect dimensions to drawing

0.00

105

OC

Memo

0.00

Quality Control

110

Weld per dwg A/R Aluminum rod Batch: **W27763** 0.00

0.00

110

Large Fab

Memo

0.00

Large Fab

1-Weld one end cap and (2) lugs as per Dwg D2842
2-Grind end cap weld flush

① 14.03.31 11

DAS
19
14.03.3

PTO \rightarrow

① 14.06.12 PD

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: JA Date: 14/07/11QA Closed: JA Date: 14/7/13

Work Order: <u>114465</u> Part No. <u>D2842-042</u> NCR No. <u>NCR 14-345 3683</u> <u>WONCR: 14-4006</u>				DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input checked="" type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input checked="" type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>	14-06-11	100	1	Material wall thickness was old. Lug was welded on the thin side of the step extension. Re weld.	DAS 16 9-89 Q52042 14/06/11	Scrap & replace	PD 14-06-11	DAS 16 9-89	DAS 16 9-89
Equip/Tooling <input type="checkbox"/>						D2622-120C: B115141			
Operator <input type="checkbox"/>						QC6	14/06/11	Q52042 14/06/11	
Material <input checked="" type="checkbox"/>						\$ 26.83			
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
--	---	---

<input type="checkbox"/> Ovalized <input checked="" type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input checked="" type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	
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Work Order ID 114465

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114465

Page 2

Item ID: D2842-042

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Step Assembly RH, 206 Float

Start Date: 3/06/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/14/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

120

QC

Memo

0.00

Quality Control

1

14.6.16

DAS
24
9-89

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

1

14.6.16

DAS
24
9-89

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

Hand Finish

Memo

0.00

Hand Finishing

1

14.6.17

Work Order ID 114465

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114465

Page 3

Item ID: D2842-042

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Step Assembly RH, 206 Float

Start Date: 3/06/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/14/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC7-Inspect Chemical Conversion Coat

0.00

150

QC

Memo

0.00

Quality Control

① 14.06.17 PD

160

Weld per dwg A/R Aluminum rod Batch **1128956**
Large Fab

0.00

160

Large Fab

Memo

0.00

Large Fab

1-Remove alodine prior to welding.
Weld end cap as per Dwg D2842.
2-Grind end cap weld flush.① 14.06.17 PD

170

QC10- Inspect visual per QSI004- ground welds

0.00

170

QC

Memo

0.00

Quality Control

1 14.6.18 **DAS
24
9-89**

Work Order ID 114465

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114465

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Item ID: D2842-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Assembly RH, 206 Float
 Start Date: 3/06/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 3/14/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC5- Inspect part completeness to step on W/O	0.00				1		146-18	DAS 24 9-89
180									
QC	Memo	0.00							
Quality Control									
185	Pressure Wash per QSI005 4.3	0.00				1		146-18	
185									
HandFinish	Memo	0.00							
Hand Finishing	***Touch up step with alodine per qsi 005 prior to powder coat***								
190	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
190									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 3:25 OVEN TEMPERATURE: 320 FINISH TIME: 3:55							1 0 14-6-18	DAS 34 9-89

Work Order ID 114465

114465

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Item ID: D2842-042 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Step Assembly RH, 206 Float
Start Date: 3/06/14 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 3/14/14 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	QC3- Inspect Part Finish	0.00							
200									
QC	Memo	0.00							
Quality Control									
210	HandFinishing	0.00							
210									
HandFinish	Memo	0.00							
Hand Finishing	1-Install inserts as per Dwg D2842 2-Wing Walk as per Dwg D2842 and QSI 005 4.1 Batch: 11125396								
220	QC5- Inspect part completeness to step on W/O	0.00							
220									
QC	Memo	0.00							
Quality Control									

DAS
15
9-89

ShpB
4/6/19

Shop Packet Print

March-06-14 7:56:18 AM

Work Order ID: 114465

114465

Parent Item: D2842-042

D2842-042

Parent Item Name: Step Assembly RH, 206 Float

Start Date: 3/06/14

Required Date: 3/14/14

Start Qty: 1.00

Required Qty: 1.00

NAS1329C3KB130

Purchased

No

210

Each

74.0000

3

3

NAS1329C3KB130

**

u u o c l i g

insert

Location

Loc Qty

Loc Code

FP001

74

m126410

24

m127836

50

x 3

NAS1515H3L

Purchased

No

210

Each

350.0000

3

3

*NAS1515H3I *

**

u u o c l i g

Washer

Location

Loc Qty

Loc Code

FG

36

102472

36

ST297

314

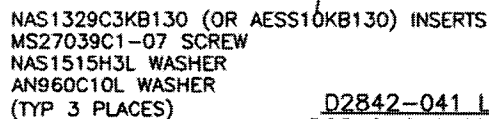
m127831

314

m128976

x 3

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**NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004**

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AES510KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER



Diagram illustrating the D2734 End Plate. The plate is shown at a 45.0 degree angle. A dimension of 1.000 is indicated for the vertical height of the plate's top edge.

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

05.11.14

RELEASED

DART

DESIGN KE	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D2842	REV. B SHEET 1 OF 1
DATE 05.09.23	TITLE 206L/407 FLOAT STEP ASSEMBLY SCALE NTS		
A	98.10.13	NEW ISSUE	
B	05.09.23	RE-DESIGN, ADD D3459-1/-3	

